

Date: Monday, 5/15/2006 11:12:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP MOUNTING LUG
Job Number	: 27121		
Estimate Number	: 11747		
P.O. Number	: N/A	Part Number	: D34591
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D3459 PRELIMINARY
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25429	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/22/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	20 Um: Each
Comment	: Est Rev: A New Issue 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
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Comment: Qty.: 0.3644 f(s)/Unit Total: 7.2870 f(s)
 4.00" X .188" BAR
 6061-T6
 (M6061T6B4.000X.188)
 Batch: M19524

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut Blanks to 4.165" Long

N/A

06/05/23

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per folio FA618 & DWG D3459
 2-Deburr

Water Jet
SAN 06:05:23

Prog Rev: A
 Dwg Rev: A

20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 06:05:23

20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06/05/25

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/05/26

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Drawing Name: FLOAT STEP MOUNTING LUG

Job Number: 27121

Part Number: D34591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



J 06/05/25



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

AD 06/05/26

Job Completion



12 06/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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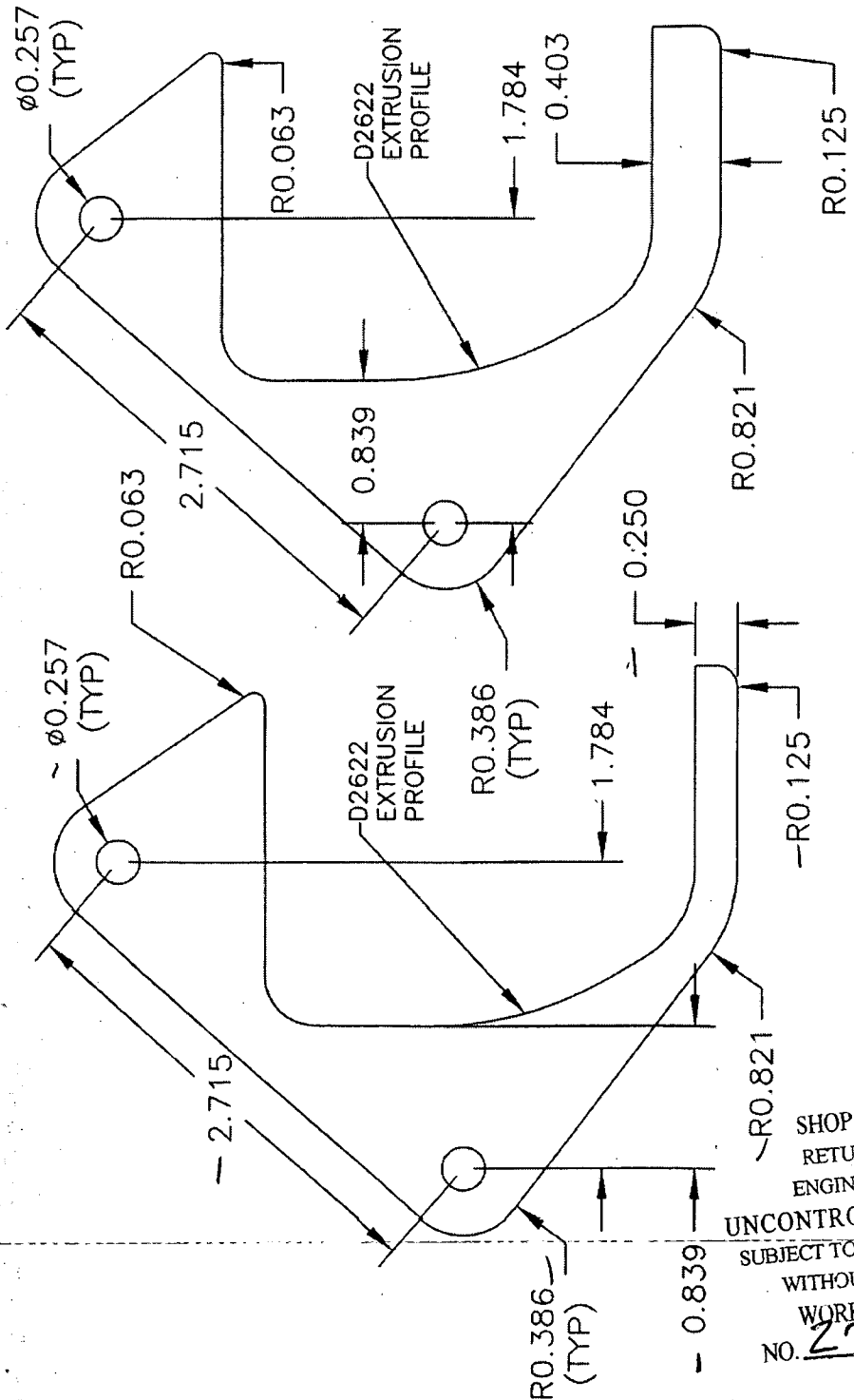
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3459	REV. A SHEET 1 OF 1
DATE 05.09.23		TITLE FLOAT STEP MOUNTING PLATE	SCALE 1:1
A	05.09.23	NEW ISSUE	



RELEASED
05.11.14 [Signature]

D3459-3 FLOAT STEP MOUNTING PLATE

D3459-1/-3 FLOAT STEP MOUNTING PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27121

- D3459-1/-3 FLOAT STEP MOUNTING PLATE
- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK (REF DART SPEC. M6061T6S.188)
 - 2) FINISH: NONE
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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